



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4151-5

Job Sheet 182381



Part No: D4151-5

Job Qty: 20 ea

Part Name: Fwd Basket Instl Stud



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEET 3 IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-2		
110	Doosan	20 pcs	9/7/18	9/7/18	0.01	6.41	Doosan		
130	QC	20 pcs	9/7/18	9/7/18	0.00	0.00	QC8		
140	Packaging	20 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2		
150	QC21-SA	20 Ea	9/7/18	9/7/18	0.00	0.00	QC21		

Part Op Descriptions: 110 - 1-Mill as per folio FA953 & dwg ,

OCT 24 2018

OCT 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	5 ft (25 ea) 328 ea	90-Start up Operation	S/115489 1534

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R1.000	5	21	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Basket Inst. Stud (Lower)	1.000Inches ± 0.030	1.030 0.970	Diameter	.999"
2	Fwd Basket Inst. Stud (Lower)	0.800Inches + 0.000 - 0.010	0.800 0.790		.794"
3	Fwd Basket Inst. Stud (Lower)	0.750Inches + 0.030 - 0.000	0.780 0.750		.758"
4	Fwd Basket Inst. Stud (Lower)	0.375Inches ± 0.010	0.385 0.365		.378
5	Fwd Basket Inst. Stud (Lower)	0.500Inches ± 0.030	0.530 0.470		.494
6	Fwd Basket Inst. Stud (Lower)	1.000Inches + 0.003 - 0.000	1.003 1.000		1.0015
7	Fwd Basket Inst. Stud (Lower)	2.000Inches ± 0.030	2.030		1.998

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

			1.970	
8	Fwd Basket Inst. Stud (Lower)	2.880Inches ± 0.030	2.910 2.850	2.878
9	Fwd Basket Inst. Stud (Lower)	0.250Inches ± 0.010	0.260 0.240	.254
10	Fwd Basket Inst. Stud (Lower)	0.438Inches $+ 0.000$ $- 0.010$	0.438 0.428	Diameter .4345
11	Fwd Basket Inst. Stud (Lower)	0.130Inches ± 0.030	0.160 0.100	.115
12	Fwd Basket Inst. Stud (Lower)	0.060Inches ± 0.030	0.090 0.030	Radius .062
13	Fwd Basket Inst. Stud (Lower)	0.250Inches $+ 0.003$ $- 0.000$	0.253 0.250	Diameter .252
14	Fwd Basket Inst. Stud (Lower)	0.130Inches ± 0.030	0.160 0.100	Radius

Plex 8/23/18 10:19 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐					
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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S120791



Part: D4151-5
Job No: 182381
Serial No/Batch: S120791

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/18